

Date: Friday, 11/18/2005 5:34:21 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEAM ASSEMBLY
Job Number :	24881		
Estimate Number :	10407		
P.O. Number :	N/A	Part Number :	D3173041
This Issue :	11/18/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3173 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	22405	Drawing Revision :	B
		Material :	N/A
		Due Date :	12/15/2005
Written By :	<u>See comment below</u>		Qty: 2 Um: Each
Checked & Approved By :	<u>See comment below</u>		
Comment :	Est. A 02.12.05 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6TR40X20W125	6061-T6 Rect Tube W.125
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Comment: Qty.: 4.9219 f(s)/Unit Total: 9.8438 f(s)
 6061-T6 Rect Tube W.125
 Material: 6061-T6 (QQ-A-200/8) Rect. Tube 4" x 2" x 0.125 thick
 (M6061T6TR4.0x2.0W125)
 Batch M19265 M8 05/12/10 2

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 56" long
 Machine holes as per Folio FA295 and Dwg D3173
 Identify as D3173-1 M8 05/12/10 2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE M8 05/12/10 2

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Ed 05/12/10 2

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK gm 05/12/12 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:34:21 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 24881

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill Ø0.316" holes as per Dwg D3173
C'sink holes as per Dwg D3173

FF 05/12/13 2

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05.12.13 2

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FF 05.12.14 2

9.0

D3178041

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut Plate
Pick K10017. Install Nut Plate as per Dwg D3173. D3178-041 is included in K10017 BOM.
Pick:

Qty	Part Number	Description	Batch
2	D3178-041	Nut Plate	B22409

FF 05/12/15 2

10.0

MS20601AD4W4

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
Rivet
Pick:

Qty	Part Number	Description	Batch
8	MS20601AD4W4	Rivet	M19278

(16x)

FF 05/12/15 2

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05-12-16 2

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3
Ensure Nut Plate thread is covered.

FL 05 12 23 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:34:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 24881

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2B 06/01/04

14.0

D3175041

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017:

BOM.

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3175-041	Mtg Lug	B24409
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FF 06-01-04

2

15.0

AN35A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

8	AN3-5A	Bolt	M14526
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FF 06-01-04

2

16.0

AN523A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	AN5-23A	Bolt	M19278
---	---------	------	--------

FF 06-01-04

2

17.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

8	AN960JD10	Washer	M19413
---	-----------	--------	--------

FF 06-01-04

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:34:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 24881

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD516	Washer	M18100

FF

06-01-04

2

19.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L5	Nut	M17653

FF

06-01-04

2

20.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble per Dwg D3173.

Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

FF

06-01-04

2

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-04

2

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as D3173-041 and Pack with D130-701-041

Location: 86

C206/01/04

2

23.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/05 : (2)

06/01/05 (2)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3173	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RELEASED
03.01.20

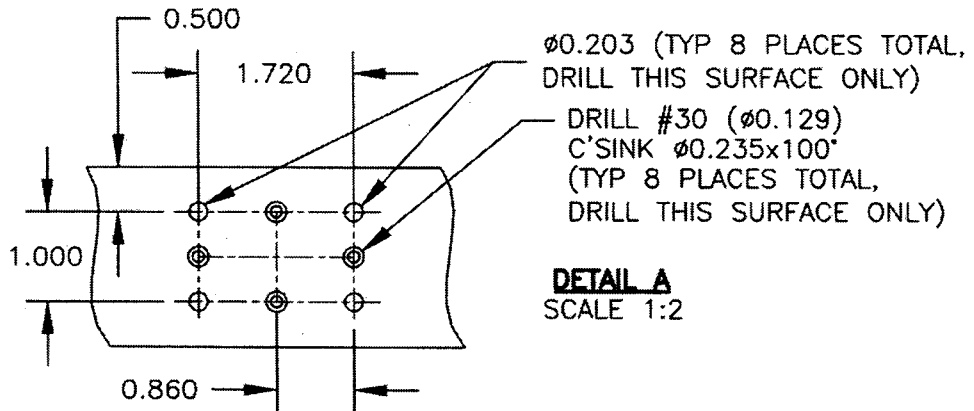
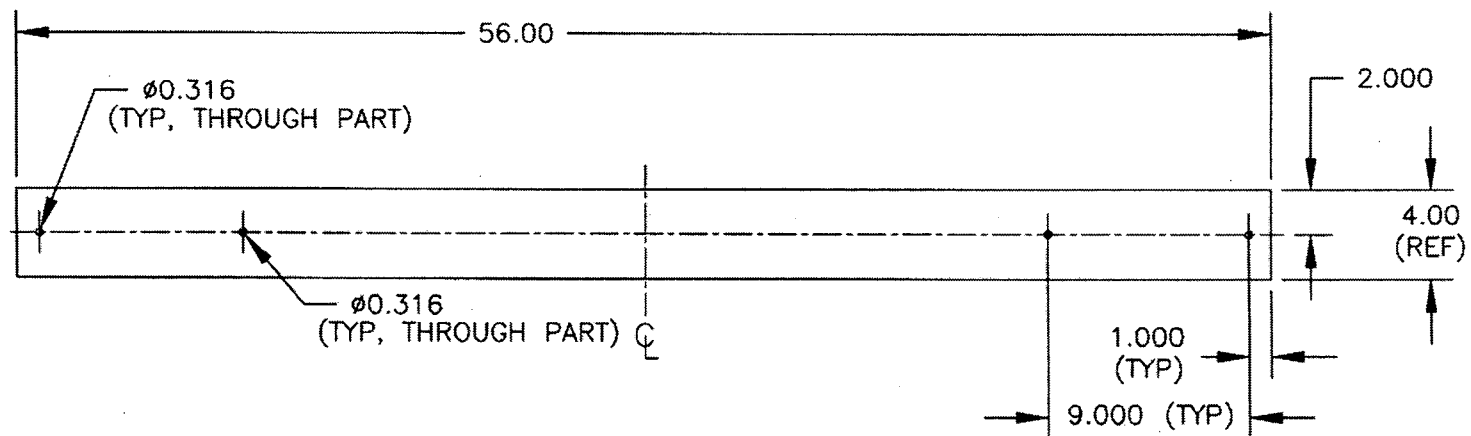
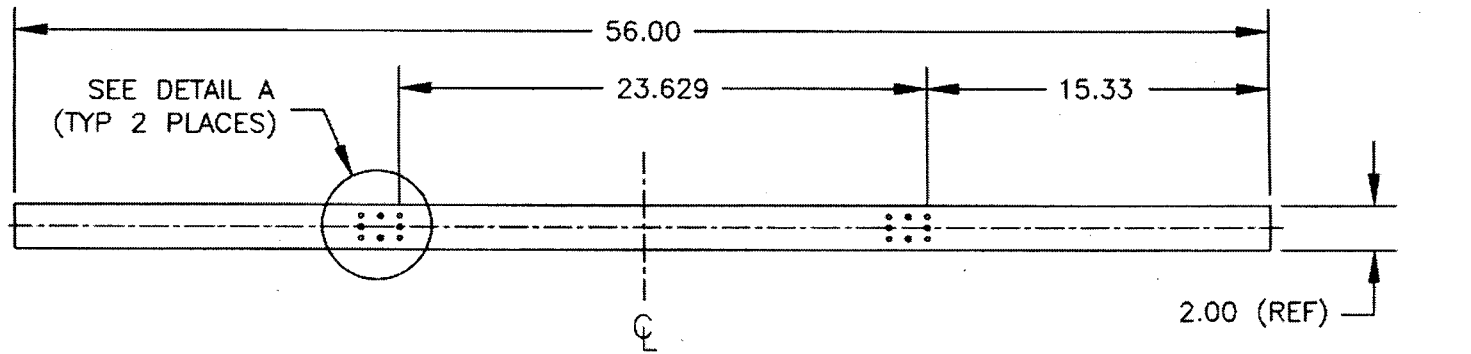
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	APPROVED	DRAWING NO. D3173	SHEET 3 OF 3
DATE 03.01.07	TITLE	BEAM ASSEMBLY	SCALE 1:8

D3173-1 BEAM



RELEASED
03.01.07

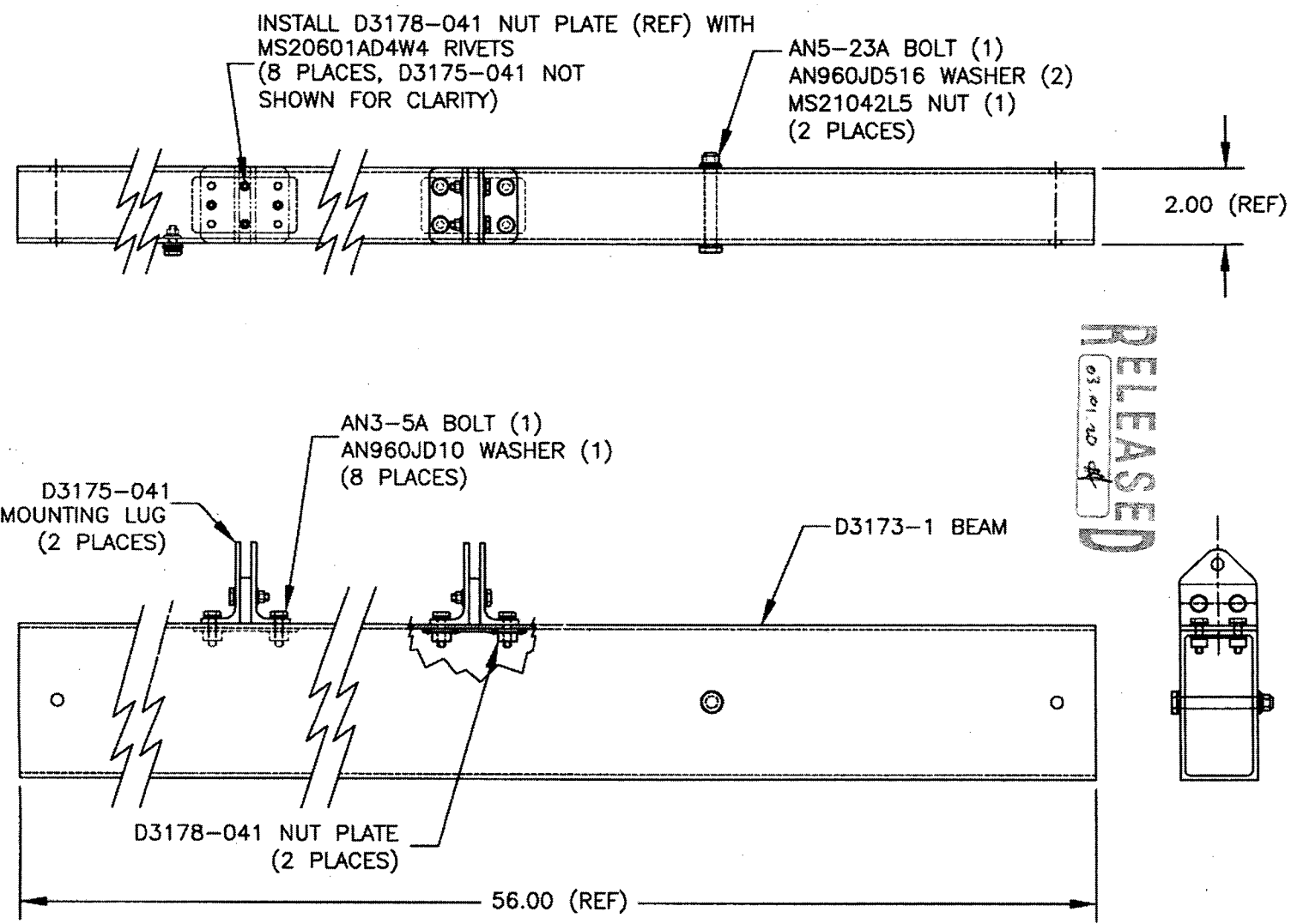
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3173	SHEET 2 OF 3
03.01.07		TITLE	SCALE
		BEAM ASSEMBLY	1:4

RELEASED
03.01.20



D3173-041 BEAM ASSEMBLY

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	: 0024881	Department Code:	
Project Name	: D3173-041	Burden Flags	: NNNNNNNN
Project For	: WK549	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3173-041	Invoice Number	:
Description	: Beam Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 2	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-18-05		
Est Finish Date	: 12-10-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00